

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004463**Date Inspected:** 31-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Li Jia	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG	

Summary of Items Observed:

On this day Caltrans Assurance Inspector (QA) Larry Viars was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Heavy Machinery Bay 3:

QA performed Phased Array Ultrasonic Testing (PAUT) after Caltrans NDE technicians performed the preliminary scan with conventional Ultrasonic Testing (UT) in the tacked areas of the Partial Joint Penetration (PJP) welds joining u-ribs to deck plates. This QA inspector performed 100 % PAUT on DP380-001 in the areas that exhibited crack like indications with conventional UT. This QA inspector confirmed crack like indications as follows:

DP-380-001: (PAUT)

Weld# 3 – 1 tacks PAUT'ed – 0 indications found noncompliant

Weld# 6 – 4 tacks PAUT'ed – 3 indications found noncompliant

Weld# 7 – 1 tack PAUT'ed – 1 indication found noncompliant * see additional information below

Weld# 8 – 3 tacks PAUT'ed – 2 indications found noncompliant

NOTE: Phased Array testing was performed in accordance with specification, UT 04-012024.

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Sub Assembly Bay 7:

Caltrans QA performed FVT and MT verification and signed yellow tags on the following OBG Floor beams welds FB011-015 B side, FB015-026 A side and FB016-027 A side. No relevant indications were noted during visual and magnetic particle testing. See MT report TL-6028, generated on this date for further information.

No other observations were made this night.

Summary of Conversations:

Only general conversations occurred between QA and QC.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, 150 0219 9593, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Wright,Mark	QA Reviewer
